

Work Order ID 80588

February-23-12 2:49:44 PM

80588

Page 1

Item ID: D4314-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Shim
 Start Date: 24/02/2012 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 09/03/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/23 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D4314	A								
100		0.00							
100									
Waterjet		0.00							
FLOW CNC Waterjet	Memo								
	1-Cut as per Dwg D4314								
	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110		0.00							
110									
QC		0.00							
Quality Control	Memo								
	QC2- Inspect parts off machine FAI/FAIB								
120		0.00							
120									
QC		0.00							
Quality Control	Memo								
	QC8- Inspect parts - second check								

W 12 02 26 (8)

W 12 02 26 (8)

5 12/02/27

(X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

80588

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 24/02/2012 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 09/03/2012 **Req'd Qty:** 8.00 ***Q***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Tool ID

Tool #

Plan
Code

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

COUNTER SINK AS PER DWG

0.00

150

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

0.00

160

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

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W/O:		WORK ORDER CHANGES					
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Page 3

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location: STB9	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

Handwritten signature and date: 12/02/29

Handwritten signature and date: (8x) SP 12-02-29

Handwritten signature and date: MCT 12/02/29

Handwritten signature and date: 12-02-29 (4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 80588

80588

Parent Item: D4314-1

D4314-1

Parent Item Name: Shim

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-02-02 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No			100	sf	101.0400	0.019	0.16			

M6061T6S 125

6061-T6 .125 Sheet

**

W 12 02 26

Location

Loc Qty

Loc Code

MAT021

101.04

113608

53.85

118217

0.09

119513

10.8

120218

36.3

1.28

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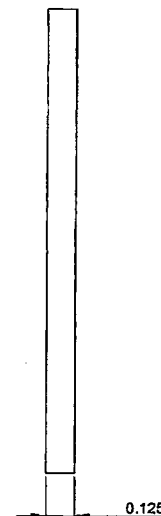
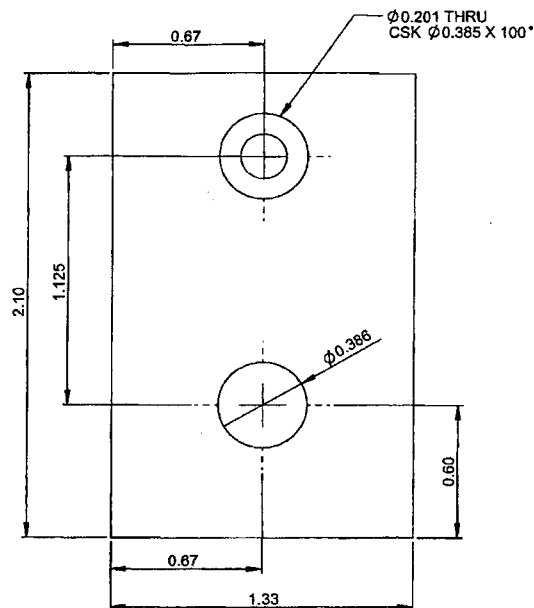
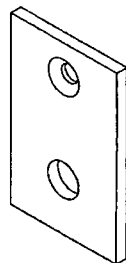
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NOTE: Date & initial all entries



SHOP COPY
FOR KETO
WORKING
UNLESS OTHERWISE NOTED
NO DIMENSION
W/OUT A DIMENSION
W/OUT A DIMENSION

80588_MLT

12/02/23

D4314-1 SHIM

RELEASED
2011-02-13
MB

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.125)
OR
ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.125)
OR
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	SC	11.01.13
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4314	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SHIM	NTS
DATE	11.01.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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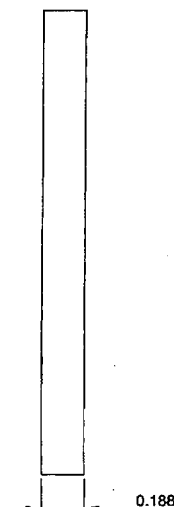
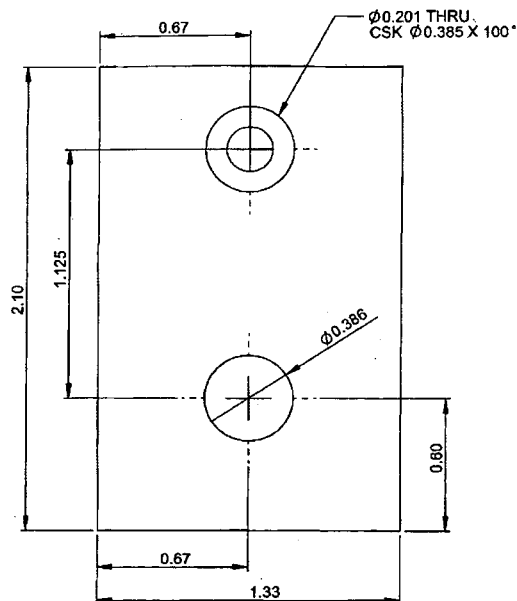
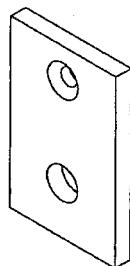
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NOTE: Date & initial all entries



D4314-3 SHIM

NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.188)
OR
ALUMINUM 6061-T6/T62 SHEET PER QQ-A-250/11 OR AMS-QQ-A-250/11
AMS 4025 OR AMS 4027 OR ASTM B209 (REF DART SPEC M6061T6S.188)
OR
ALUMINUM 5052-H32 SHEET PER QQ-A-250/8 OR AMS-QQ-A-250/8
AMS 4016 OR ASTM B209 (REF DART SPEC M5052H32S.188)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SP	DRAWING NO.	REV. A
MFG. APPR.	SP	D4314	SHEET 2 OF 2
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DE APPR.	SP	SHIM	NTS
DATE	11.01.13	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
2011-02-01
MP

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